

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008555**Date Inspected:** 18-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin, Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG& Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-1AAE-1AE

FCAW welding process of weld joint 500 located on PCMK SEG2E. Welder is identified as 058245ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 504 located on PCMK SEG2E. Welder is identified as 045133ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 517 located on PCMK SEG2E. Welder is identified as 045276ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

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FCAW welding process of weld joint 520 located on PCMK SEG2E. Welder is identified as 050316ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

SMAW welding process of weld joint 009 located on PCMK OBE1. Welder is identified as 058242ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

FCAW welding process of weld joint 010 located on PCMK OBE1. Welder is identified as 047864ZPMC QC is identified as Pan Wen Long. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

BAY#10

This QA Inspector randomly observed the following work in progress.

This QA Inspector observed ZPMC personnel performing FCAW welding for buildup on bottom edge of skin 'B' North tower lift 1. Welders are identified as 057244 and 050041 ZPMC QC is identified as Tu Jun. The welding variables recorded by QC appeared to comply with the WPS-345-FCAW-3G (3F) Repair. The critical weld repair report noted as T-CWR055.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
